



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

15329

D5152-7

Job Sheet 193259



Part No: D5152-7

Job Qty: 10 pcs

Part Name: Aft Step Post



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: 15329

Due Date: 6/20/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 15-01-08 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	10 pcs	6/20/19	6/20/19	0.00	1.01	Doosan - 1		DAS 5 9-89
110	QC 2	10 pcs	6/20/19	6/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		DAS 5 9-89
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Container No: S180417



Part: D5152-7

Job No: 193259

Serial No/Batch: S180417

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/12/19

				QC 2 - 5	Plex 4/9/19 4:07 PM Dart.Macdonald.Dara
				QC 2 - 71	
120	QC 8	10 pcs	6/20/19	0.00 0.00	QC 8 - 12
				QC 8 - 14	2nd 19/05/13
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
150	Packaging 3-1 - Stock - B4B	10 pcs	6/20/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B

				Packaging 3 - 35 - B4B	Plex 4/9/19 4:07 PM Dart.Macdonald.Dara
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	10 pcs	6/20/19	0.00 0.00	QC 21 - SA - 21	DAS MAY 27 2019
				QC 21 - SA - 70	21
				QC 21 - SA - 53	11-50

Part Op 100 - Doosan Lathe
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 150 - Identify as per dwg & Stock Location:
 170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.750	304 SS Roundbar .750	.2500 ft (-025 ea)	100-Doosan - 1	152403

(0.04/ea)

14/10 Fx

40"

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M304R0.750	0	15	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Aft Step Post	1.300Inches ± 0.130	1.430 1.170	Radius	
2	Aft Step Post	0.060Inches ± 0.030	0.090 0.030		
3	Aft Step Post	45.0Degrees ± 0.5	45.5 44.5		
4	Aft Step Post	0.200Inches ± 0.030	0.230 0.170		
5	Aft Step Post	0.725Inches (0.008 0.001)	(0.733 0.724)		V-10/10

Plex 4/9/19 4:07 PM Dart.Macdonald.Dara